

# Work Order ID 119937

May-30-14 8:41:40 AM

**\*119937\***

Page 1

Item ID: D350-636-017

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: MLS Date: 14-05-30 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4168-043	B

*M.A.D.*

100 Document Control 0.00

**\*100\***

DOCUMENT CONTROL

DC Memo 0.00

Doc.Control -USB or Paperwork

Memo Photocopy blue file and type labels per PPP D350-636-017 CHG 005

DAS  
06  
9-89 JUL 10 2014

*1* *mini*

*89.90*



Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 2

Item ID: D350-636-017

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Stop \*NS2\*

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

110

0.00

\*110\*

Skidtubes

0.00

Skidtubes

Skidtubes

**Memo**

1- Pick D2600-3 Bent

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside AFT end per dwg D4168

3- Drill pilot holes for blade fitting bolt holes using DT8983. Start with 3/16", then open to 0.500" using center drill then ream holes using 0.500" reamer. PIN first side. Repeat process on second side.

\*\*\*ENSURE PROPER POSITIONING FWD BEND MUST BE FACING UP WHEN DRILLING FIRST SIDE\*\*\*

Drill pilot holes using drill Jig DT8150 & DT8864A for first side only DT8864B for second side.

4- Locate DT8330 off of blade fitting bolt holes and drill pilot holes for blade fitting

5- Drill fwd step holes using DT9616 detail S. Ensure proper positioning.

6- Drill pilot holes for wearplates as per Dwg D4168 using DT9678. Locating from 66.54" holes.

7- Open up holes of Detail S to 0.297" (total of 2 holes per side) +.201" (total of 1 per side)

8- Weld D2744 Cap as per Dwg D4168 and QSI 004. Fill grooves in bend left from bending as per QSI 004

14-6-2 JH/DH

14/06/04

BB14-0604

Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 3

Item ID: D350-636-017

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

A/R Aluminum Rod batch: M127763

9-Grind welds flush as per Dwg D4168

7 BR14-06-04

120 QC10- Inspect visual per QSI004- ground welds 0.00

\*120\*

QC

Memo 0.00

Quality Control

① 14-06-05

DAS  
9  
9-89

130 QC5- Inspect part completeness to step on W/O 0.00

\*130\*

QC

Memo 0.00

Quality Control

① 14-06-05

DAS  
9  
9-89

Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 4

Item ID: D350-636-017

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Stop \*NS2\*

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140	Chemical Conversion Coat per QSI005 4.1	0.00							
*140*									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC7-Inspect Chemical Conversion Coat	0.00							
*150*									
QC	Memo	0.00							
Quality Control									

D6C / 14-6-5  
PLM

① 14/06/05

Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 5

Item ID: D350-636-017

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

160

0.00

\*160\*

Skidtubes

0.00

Skidtubes

Memo

Skidtubes

1-Open up holes using hole saw of Detail C and ground handling to 0.625"  
(total of 8 holes per side)  
as per dwg D4168.

2-Open up holes using hole saw of Detail B to 0.750" (total of 4 holes per side)  
as per dwg D4168.

3- Open float hole using uni-bit to 0.500" (4 per side)

4-Chamfer holes of Detail B, C, ground handling and float holes per dwg D4168  
(welding instructions on sheet 8)

5-Deburr and blow out all chips from inside of tube

6- Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015, let cure for 12hrs.

A/R Sikaflex-291 batch: 128563  
exp. date: 14-11-20

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D4168 & QSI004  
(welding instructions on sheet 8)

A/R Aluminum Rod batch: M127763

9- At section AJ-AJ drill out x-bolt spacer to 0.404"

10-Grind welds flush as per Dwg D2750

- DC 14/06/10

DC 14/06/05

DGC / ALM

14-6-5

BB14-06-10

# Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 6

Item ID: D350-636-017 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible  
 Start Date: 5/30/14 Start Qty: 1.00 \*1\* Cust Item ID:  
 Required Date: 5/30/14 Req'd Qty: 1.00 \*1\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

11-Spot face ground handling holes section (total of 4 places per side) as per - *DL 14/06/10*  
 dwg D2750

12- C'bore section CJ-CJ. ADJUST TOOLING AS REQUIRED.  
 VERF BY: *DL*

13- Deburr holes, ensure tube is free of all scratches before sending to paint.

*100* \*\*\*\*\* FOR DELUXE SKIDTUBE IF APPLICABLE DRILL TOW RING  
 HOLE IN TUBE \*\*\*\*\*  
 \*\*\*\*\*REF TO W/O BATCH: \_\_\_\_\_ \*\*\*\*\*

170

\*170\*

QC

Quality Control

QC10- Inspect visual per QSI004- ground welds 0.00

Memo

0.00

*5/14/20*

Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 7

Item ID: D350-636-017

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

180

QC5- Inspect part completeness to step on W/O

0.00

\*180\*

QC

Memo

0.00

Quality Control

190

Pressure Wash per QSI005 4.3

0.00

\*190\*

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

200

0.00

\*200\*

SprayPaint

Memo

0.00

Spray Painting

1- PRIME AS PER DWG AND QSI 005 4.2  
PRIMER PRC DESOTO 515X349 BATCH: 1289752- PAINT WHITE AS PER DWG AND QSI 005 4.2  
PAINT BATCH: 129269

1 7/19 14-6-25

1 0 0 AS

14-7-1



Work Order ID 119937

May-30-14 8:41:40 AM

\*119937\*

Page 8

Item ID: D350-636-017

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 \*1\*

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 \*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	QC14- Inspect Spray Paint	0.00							
*210*									
QC	Memo	0.00							
Quality Control	Inspect for foreign object per QSI 024								
230	HandFinishing	0.00							
*230*									
HandFinish	Memo	0.00							
Hand Finishing	1- Install inserts as per Dwg D4168								
	2-Inspect for Foreign Objects								
	3-Install blade fitting D3488-041, wearshoes and ground handling hardware as per dwg D4168								
	SIKA FLEX 241								
	BATCH: M129457								
	EXP DATE: 1/1/15								
	4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube								
	A/R 55-o'ring lube batch: M12637								
	5-Coat all exposed fasteners with "LPS Procyon"								
	batch: M12290								

1 of 4-7-2 045 34 9-89

164 of 11 102103

RTU 598136W M125792 exp 15/09

May-30-14 8:41:40 AM

Page 9

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

DAS  
31  
9-89

**Work Order ID 119937**

May-30-14 8:41:40 AM

**\*119937\***

Page 10

Item ID: D350-636-017

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14 Start Qty: 1.00 **\*1\***

Cust Item ID:

Required Date: 5/30/14 Req'd Qty: 1.00 **\*1\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
270	Packaging	0.00							
<b>*270*</b>									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-636-017								
	Location: <u>071</u>								
	PPP rev: <u>1</u>								
280	QC21- Final Inspection - Work Order Release	0.00							
<b>*280*</b>									
QC	Memo	0.00							
Quality Control									

14/7/10

MLJ 14-07-14  
MLJ 14-07-11

# Picklist Print

May-30-14 8:41:43 AM

Page 1

Work Order ID: 119937

\*119937\*

Parent Item: D350-636-017

\*D350-636-017\*

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.09.28 new issue DD verf:EC IPP Rev:B  
11.04.14 ecn11-553 DD verf:EC IPP Rev:C 11.10.18 as  
per NCR 11-906 DD verf:EC IPP Rev:D 112.04.16 AS PER ECN  
12-542 DD verf:EC IPP REV:E 13.08.28 PER ECN13-594 DD  
VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3490-1		Manufactured	No			160	Each	115.0000	4	4			
*D3490-1*									**			8/14/06-10	
Cross Bolt Spacer													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					LG			115					
					112737			1					
					116358			114					
AN3C34A		Purchased	No			230	Each	32.0000	1	1			
*AN3C34A*									**			all 10/6/03	
BOLT													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					ST352			32					
					m127044			32					
AN3C36A		Purchased	No			230	Each	170.0000	4	4			
*AN3C36A*									**			all 10/6/03	
Bolt													
					<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>			
					FG			25					
					101261			4					
					122204			11					
					124827			10					
					ST514			145					
					m127769			5					
					m128398			65					
					m128773			75					

# Picklist Print

May-30-14 8:41:43 AM

Page 2

Work Order ID: 119937

\*119937\*

Parent Item: D350-636-017

\*D350-636-017\*

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN3C37A Purchased No 230 Each 386.0000 1 1

Start Qty: 1.00

Required Qty: 1.00

\*AN3C37A\*  
BOLT

DAS  
06  
9-89

Location	Loc Qty	Loc Code
ST353	10	
M124131	1	
M127823	9	
ST514	376	
M128491	176	
M128773	200	

DAS  
28  
9-89

JUL 10 2014

DAS  
31  
9-89

AN3C42A Purchased No 230 Each 40.0000 1 1

\*AN3C42A\*  
Bolt

DAS  
06  
9-89

Location	Loc Qty	Loc Code
FG	5	
121103	5	
ST353	35	
m127300	1	
m128491	9	
m128830	25	

DAS  
28  
9-89

DAS  
31  
9-89

D3490-5 Manufactured No 230 Each 32.0000 4 4

\*D3490-5\*  
Cross Bolt Spacer

Location	Loc Qty	Loc Code
LG001	32	
109104	32	

BE1406-R

May-30-14 8:41:43 AM

Shop Packet Print

Page 2

# Picklist Print

May-30-14 8:41:43 AM

Page 3

Work Order ID: 119937

\*119937\*

Parent Item: D350-636-017

\*D350-636-017\*

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3492-1

Manufactured No

230 Each

Start Qty: 1.00  
144.0000 8 8

Required Qty: 1.00

\*D3492-1\*

Plug

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FP001

144

111578

2

112738

8

114879

134

D3492-5

Manufactured No

230 Each

129.0000 8 8

\*D3492-5\*

Plug

\*\*

N/A PTO LAST PAGE 7

Location

Loc Qty

Loc Code

FP001

129

104854

9

105612

39

112740

81

D3873-1

Manufactured No

230 Each

223.0000 7 7

\*D3873-1\*

Bushing

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

ST067

223

104858

5

105611

217

109110

1

D4154-041

Manufactured No

230 Each

4.0000 1 1

\*D4154-041\*

Wearplate Assembly

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FP002

4

106716

1

114212

3

May-30-14 8:41:43 AM

Shop Packet Print

Page 3

# Picklist Print

May-30-14 8:41:43 AM

Page 4

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D4170-1

Manufactured No

230

Each

Start Qty: 1.00  
101.0000 4 4

Required Qty: 1.00

**\*D4170-1\***

Bushing

\*\*

*BE 4-06-10*

Location

Loc Qty

Loc Code

LG001

101

*(107896)*

101

D4171-1

Manufactured No

230

Each

15.0000 1 1

**\*D4171-1\***

Bushing

\*\*

*all 11-07-03*

Location

Loc Qty

Loc Code

ST098

15

109144

15

MS21043-3

Purchased No

230

Each

528.0000 5 5

**\*MS21043-3\***

Nut

\*\*

*all 11-07-03*

Location

Loc Qty

Loc Code

FG

80

103691

80

ST315

55

124555

35

m126741

20

ST509

393

m128398

393

*X5*

May-30-14 8:41:43 AM

Shop Packet Print

Page 4

# Picklist Print

May-30-14 8:41:43 AM

Page 5

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0363R

Purchased

No

230

Each

Start Qty: 1.00  
1,265.000 9 9

Required Qty: 1.00

**\*NAS1149C0363R\***

Washer

\*\*

20 11/07/03

Location

Loc Qty

Loc Code

FP001

580

114742

580

Return2014

6

114742

6

ST292

679

122441

79

m128591

600

NAS1515H3L

Purchased

No

230

Each

483.0000 4 4

**\*NAS1515H3L \***

Washer

\*\*

20 11/07/03

Location

Loc Qty

Loc Code

FG

40

102472

40

ST297

443

m127831

159

m128976

284

NAS1611-005

Purchased

No

230

Each

171.0000 8 8

**\*NAS1611-005\***

O-RING

\*\*

N/A PTO last page →

Location

Loc Qty

Loc Code

FP001

171

m126974

96

m129198

75

May-30-14 8:41:43 AM

Shop Packet Print

Page 5



# Picklist Print

May-30-14 8:41:43 AM

Page 6

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1611-010

Purchased

No

230

Each

Start Qty: 1.00  
195.0000 8 8

Required Qty: 1.00

**\*NAS1611-010\***

O-RING

\*\*

*11/04/02*

Location

Loc Qty

Loc Code

FP001

195

*M129405*

*V8*

m126988

3

m127813

4

m128375

80

m128388

8

m129198

100

NAS1149D0863J

Purchased

No

250

Each

859.0000 2 2

**\*NAS1149D0863.J\***

Washer

\*\*

DAS  
28  
9-89

**JUL 07 2014**

Location

Loc Qty

Loc Code

FP001

2

118078

2

ST293

57

125484

57

*2X*

ST510a

800

125268

600

125635

200

D2744

Manufactured

No

110

Each

21.0000 1 1

**\*D2744\***

Cap

\*\*

*BE140604*

Location

Loc Qty

Loc Code

LG001

21

*115440*

21

May-30-14 8:41:43 AM

Shop Packet Print

Page 6

# Picklist Print

May-30-14 8:41:43 AM

Page 7

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2600-3-BENT

Manufactured No

110 Each

Start Qty: 1.00  
8.0000 1 1

Required Qty: 1.00

**\*D2600-3-BFNT\***

Extrusion Bent

\*\*

Location

Loc Qty

Loc Code

LG  
117904  
LG002  
112976

7  
7  
1  
1

124.0000 8 8

\*\*

D2743

Manufactured No

160 Each

**\*D2743\***

Crossbolt Spacer

Location

Loc Qty

Loc Code

LG  
111570  
112729  
LG001  
109799

123  
8  
115  
1  
1

12.0000 1 1

\*\*

D2739

Manufactured No

160 Each

**\*D2739\***

350 I Beam

Location

Loc Qty

Loc Code

LG  
111094  
113252  
117803  
LG002  
115881

5  
1  
1  
3  
7  
7

① 14-6-2 DGC  
BE 14-06-10

8

① DGC 14-6-5

May-30-14 8:41:43 AM

Shop Packet Print

Page 7

# Picklist Print

May-30-14 8:41:43 AM

Page 8

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

ALS4-1032-225

AELS8-1032-225 Purchased

No

230

Each

Start Qty: 1.00  
765.0000 4 4

Required Qty: 1.00

**\*ALS4-1032-225\***

Rivnut

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FG	30	
M127028	30	
FP001	461	
M128649	461	
ST280	248	X-1
M127028	10	
M128179	238	
st555	26	
M127092	26	

AN8C35A

Purchased

No

230

Each

55.0000 1 1

**\*AN8C35A\***

Bolt

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FG	4	
121275	4	
FP001	51	
m126293	29	
m127823	22	✓1

D3488-041

Manufactured

No

230

Each

9.0000 1 1

**\*D3488-041\***

Blade Fitting LH

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FP001	9	
111463	8	X1
88255	1	

May-30-14 8:41:43 AM

Shop Packet Print

Page 8

# Picklist Print

May-30-14 8:41:43 AM

Page 9

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

AN6C44A

Purchased

No

230

Each

Start Qty: 1.00  
127.0000 4 4

Required Qty: 1.00

**\*AN6C44A\***

Bolt

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FG	2	
103964	2	
ST341	28	
m128319	28	
ST505	97	
m128700	47	
m129199	50	

x4

MS21083C8

Purchased

No

230

Each

161.0000 1 1

**\*MS21083C8\***

Nut

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

ST319	11	
m127255	5	
m128119	6	
ST508	150	
m128798	150	

v1

D3631-1

Manufactured

No

230

Each

180.0000 8 8

**\*D3631-1\***

Washer

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

FP001	180	
110258	16	
111019	12	
115800	52	
119553	100	

v8

May-30-14 8:41:43 AM

Shop Packet Print

Page 9

# Picklist Print

May-30-14 8:41:43 AM

Work Order ID: 119937

\*119937\*

Parent Item: D350-636-017

\*D350-636-017\*

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0332R

Purchased

No

230

Each

Start Qty: 1.00  
5,700.000 4 4

Required Qty: 1.00

\*NAS1149C0332R\*

WASHER

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

GA

825

125654

825

11 129499

24

Return2014

41

122063

41

ST292

1676

124580

8

125654

8

m128591

1660

st510

3158

m126319

61

m127306

2500

m127410

563

m127831

34

D2745

Manufactured

No

230

Each

78.0000 8 8

\*D2745\*

Bushing

\*\*

all 11/07/03

Location

Loc Qty

Loc Code

ST017

78

107336

4

B117099

28

111554

8

113176

58

90323

2

93336

6

# Picklist Print

May-30-14 8:41:43 AM

Page 11

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

NAS1149C0832R

Purchased

No

230

Each

Start Qty: 1.00  
290.0000 1 1

Required Qty: 1.00

**\*NAS1149C0832R\***

Washer

\*\*

11/07/03

Location

Loc Qty

Loc Code

ST292

290

122441

23

m114915

117

m125807

150

✓1

AN3C6A

Purchased

No

230

Each

1,265.0000 4 4

**\*AN3C6A\***

Bolt

\*\*

11/07/03

Location

Loc Qty

Loc Code

FG

10

122416

10

ST351

2

m128224

2

ST513

1253

m125709

257

m128769

996

✓4

MS21043-6

Purchased

No

230

Each

218.0000 4 4

**\*MS21043-6\***

NUT

\*\*

11/07/03

Location

Loc Qty

Loc Code

FG

20

103693

20

ST315

10

m127255

10

ST509

188

m127813

188

✓5

May-30-14 8:41:43 AM

Shop Packet Print

Page 11

# Picklist Print

Page 12

May-30-14 8:41:43 AM

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D3493-1 Manufactured No 250 Each 199.0000 2 2 Start Qty: 1.00 Required Qty: 1.00

**\*D3493-1\***

Washer

\*\*

DAS  
28  
9-89

JUL 07 2014

DAS  
06  
9-89

Location	Loc Qty	Loc Code
FG	10	
97201	10	
ST051	189	
109105	159	
112741	30	

DAS  
31  
9-89

MS21083C8 Purchased No 250 Each 161.0000 2 2

**\*MS21083C8\***

Nut

\*\*

DAS  
28  
9-89

DAS  
31  
9-89

DAS  
06  
9-89

Location	Loc Qty	Loc Code
ST319	11	
m127255	5	
m128119	6	
ST508	150	
m128798	150	

AN8C21A Purchased No 250 Each 49.0000 2 2

**\*AN8C21A\***

Bolt

\*\*

DAS  
28  
9-89

DAS  
31  
9-89

DAS  
06  
9-89

Location	Loc Qty	Loc Code
ST	2	
123966	2	
ST341	2	
m127061	2	
ST342	3	
m128319	2	
m128849	1	
ST508	42	
m127823	42	

May-30-14 8:41:43 AM

Shop Packet Print

Page 12

# Picklist Print

May-30-14 8:41:43 AM

Page 13

Work Order ID: 119937

**\*119937\***

Parent Item: D350-636-017

**\*D350-636-017\***

Parent Item Name: Skidtube LH Run-On Landing Wearplates Air-Cruiser / Apical Tri-Bag Float  
Compatible

Start Date: 5/30/14

Required Date: 5/30/14

D2741

Manufactured No

250

Each

34.0000

Start Qty: 1.00

Required Qty: 1.00

\*\*

121976

DAS  
28  
9-89

**\*D2741\***

Blade

DAS  
06  
9-89

Location

Loc Qty

Loc Code

FG

14

100664

5

115522

5

98323

4

FP001

1

88824

1

ST466

19

107206

2

113640

12

115522

5

DAS  
31  
8-89

May-30-14 8:41:43 AM

Shop Packet Print

Page 13



QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D4168-041	350 SKIDTUBE ASSEMBLY, LH
	X			D4168-042	350 SKIDTUBE ASSEMBLY, RH
		X		D4168-043	350 SKIDTUBE ASSEMBLY, LH
			X	D4168-044	350 SKIDTUBE ASSEMBLY, RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1		1		D3488-041	BLADE FITTING, LH
	1		1	D3488-042	BLADE FITTING, RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
8	8	8	8	D3631-1	WASHER
7	7	7	7	D3873-1	BUSHING
1	1	1	1	D4154-041	WEARPLATE ASSEMBLY
1				D4168-1	SKIDTUBE WELDMENT, LH
	1			D4168-2	SKIDTUBE WELDMENT, RH
		1		D4168-3	SKIDTUBE WELDMENT, LH
			1	D4168-4	SKIDTUBE WELDMENT, RH
4	4	4	4	D4170-1	SPACER
1	1	1	1	D4171-1	BUSHING
4	4	4	4	ALS4-1032-225	INSERT
4	4	4	4	AN3C6A	BOLT
1	1	1	1	AN3C34A	BOLT
4	4	4	4	AN3C36A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
9	9	9	9	AN960C10	WASHER (OR NAS1149CO363R)
4	4	4	4	AN960C10L	WASHER (OR NAS1149CO332R)
1	1	1	1	AN960C816L	WASHER (OR NAS1149CO832R)
5	5	5	5	MS21043-3	NUT
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

#### GENERAL NOTES:

- 1) MATERIAL: MAKE D4168-1/2/3/4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.  
STANDARD: PRIME (REF. 4.2.1.3.3) AND PAINT WHITE PER DART QSI 005 4.2  
B. OPTIONAL: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D4168-041/-042/-043/-044 = 32.3 LBS
- 8) WELD PER DART QSI 004
- 9) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:  
MINIMUM YIELD TENSILE STRENGTH = 35 KSI  
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 10) COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY, CLEAN EXCESS OFF  
FINISH WITH MEK DEGREASER.
- 11) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT

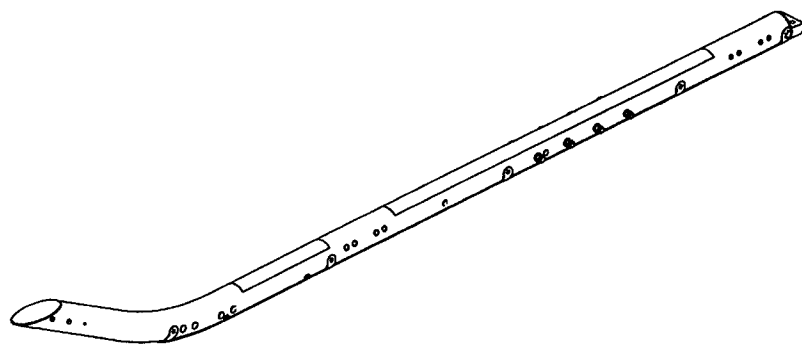
WITHOUT NOTICE  
WORK ORDER

NO. 119937 MJS

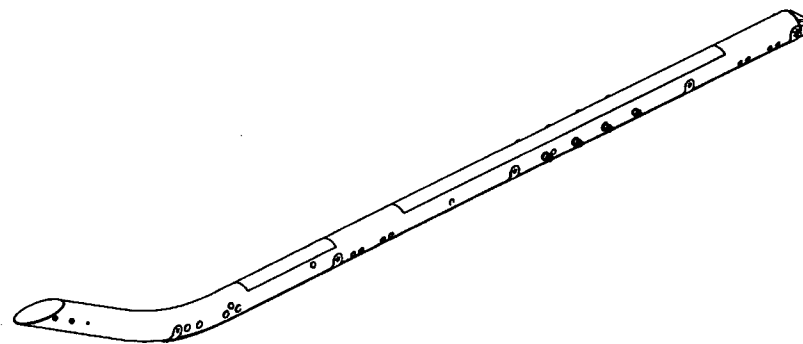
14-05-30

RELEASED  
2013-08-13  
JMP

B	ADD VIEW TO CONTROL FWD BEND ORIENTATION (ZN D-1-47-54-6-7); UPDATED FINISH OPTIONS. REASON: PARTS-276 AND NCR13-2757	MB	13.07.11
A	NEW ISSUE	SC	10.08.09
REV.	DESCRIPTION	BY	DATE
DESIGN	SC	DART AEROSPACE USA, INC.	
DRAWN	JB	KENT, WA	
CHECKED	SC	DRAWING NO.	REV. B
MFG. APPR.	SC	D4168	SHEET 1 OF 11
APPROVED	SC	TITLE	SCALE
DE APPR.	SC	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



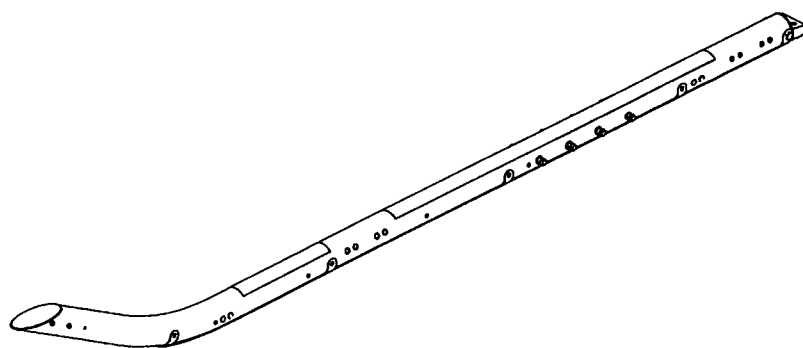
**D4168-041 350 SKIDTUBE ASSEMBLY, LH**



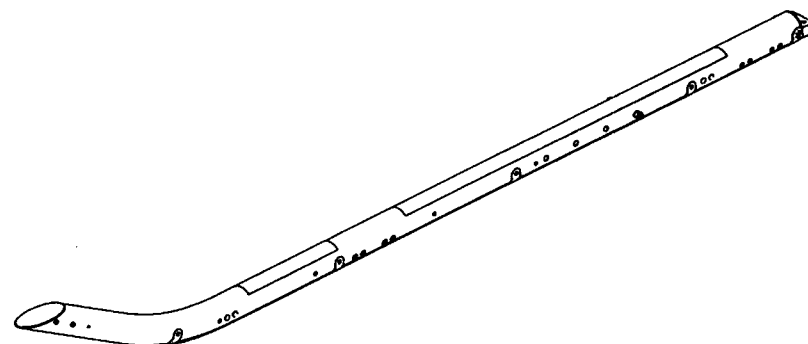
**D4168-042 350 SKIDTUBE ASSEMBLY, RH**

**RELEASE**  
2013-08-13  
*AW*

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	<i>[Signature]</i>	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	<i>[Signature]</i>	D4168	SHEET 2 OF 11
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	350 SKIDTUBE ASSEMBLY	NTS
DATE	13.07.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.</small> <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	



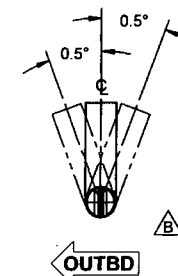
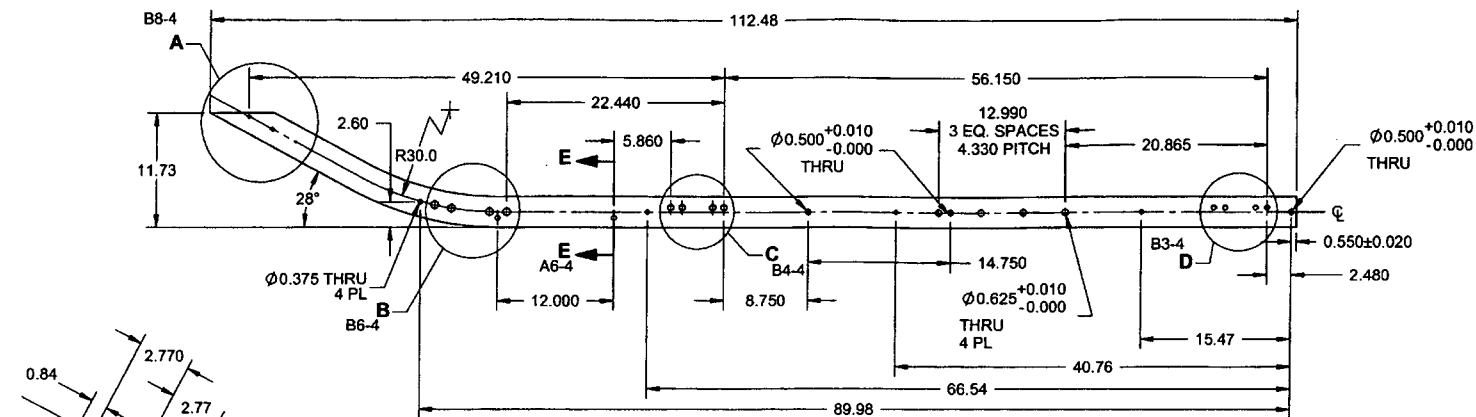
D4168-043 350 SKIDTUBE ASSEMBLY, LH



D4168-044 350 SKIDTUBE ASSEMBLY, RH

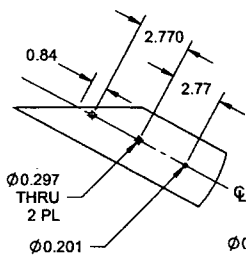
**RELEASED**  
2013-08-13  
MPD

DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JB	KENT, WA	
CHECKED	JB	DRAWING NO.	REV. B
MFG. APPR.	JB	<b>D4168</b>	SHEET 3 OF 11
APPROVED	JB	TITLE	SCALE
DE APPR.	JB	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
DATE	13.07.11	<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

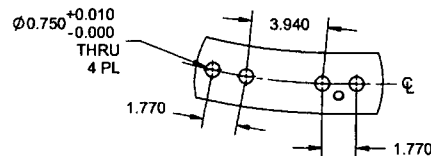


MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

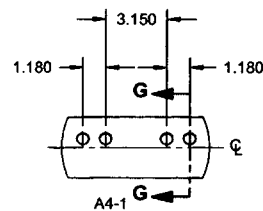
# **D4168-1 LH SKIDTUBE**



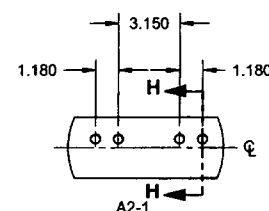
**DETAIL A**  
SCALE 2X



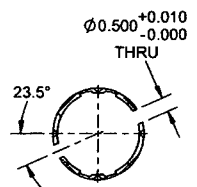
**DETAIL B**  
SCALE 2X



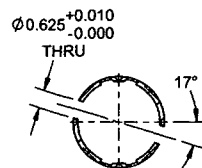
**DETAIL C**  
SCALE 2X



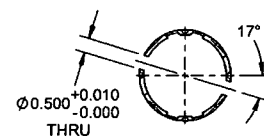
**DETAIL D**  
SCALE 2X



**SECTION E-E**  
SCALE 3X, 2 PL



**SECTION G-G**  
SCALE 3X, 4 PL



**SECTION H-H**  
SCALE 3X, 4 PL

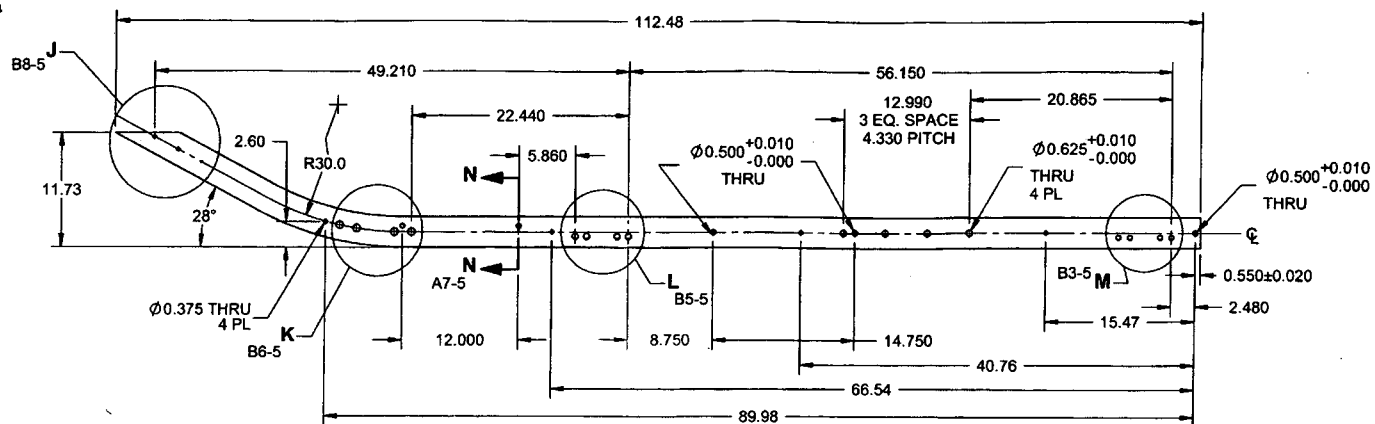
DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

**DART AEROSPACE USA, INC.**  
KENT, WA

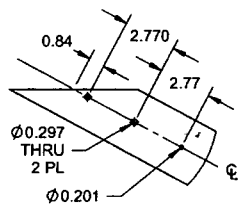
DRAWING NO. **D4168**  
TITLE **350 SKIDTUBE ASSEMBLY**  
REV. A  
SHEET 4 OF 11  
SCALE  
NTS

COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AEROSPACE USA, INC.

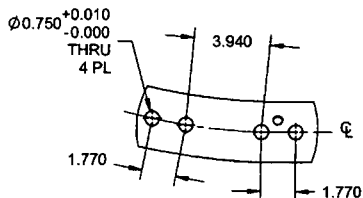
**RELEASED**  
2013-08-13



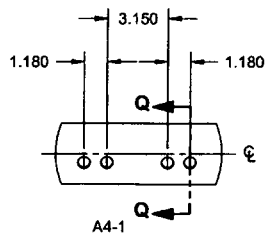
# **D4168-2 RH SKIDTUBE**



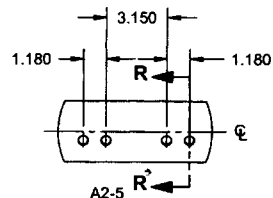
**DETAIL J**  
SCALE 2X



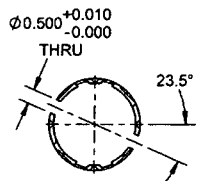
**DETAIL K**  
SCALE 2X



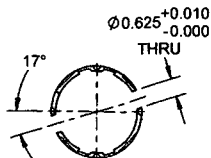
**DETAIL L**  
SCALE 2X



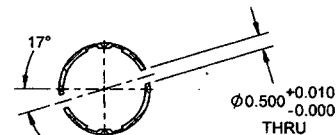
**DETAIL M**  
SCALE 2X



**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL

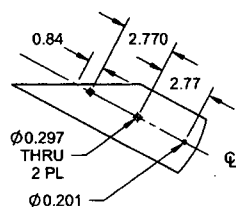
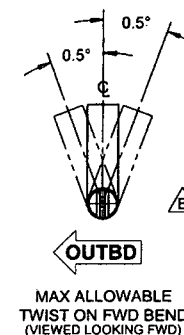
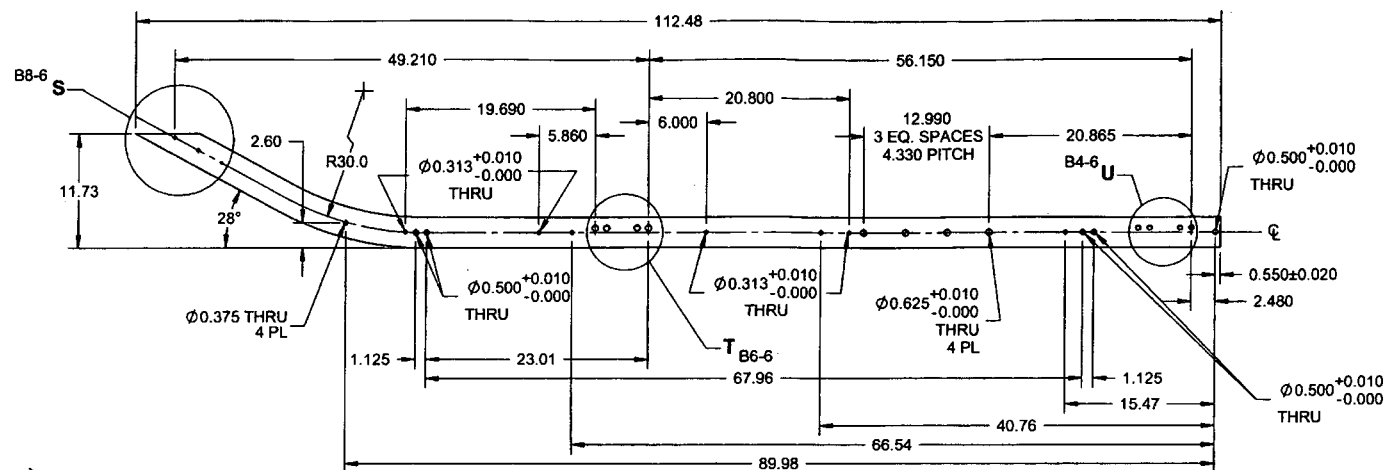


**SECTION R-R**  
SCALE 3X, 4 PL

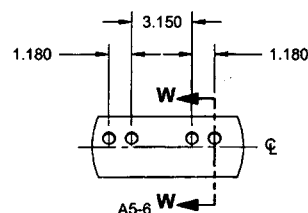
**RELEASED**  
2013-08-13

DESIGN		SC		DART AEROSPACE USA, INC.	
DRAWN		[Signature]		KENT, WA	
CHECKED		[Signature]		REV. B	
MFG. APPR.		[Signature]		DRAWING NO. D4168	
APPROVED		[Signature]		SHEET 5 OF 11	
DE APPR.		[Signature]		TITLE	
DATE 13.07.11				350 SKIDTUBE ASSEMBLY	
				SCALE NTS	
<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>					

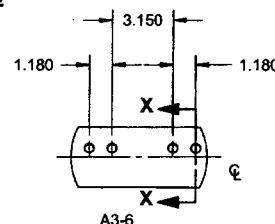




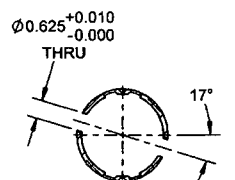
**DETAILS S**  
SCALE 2X



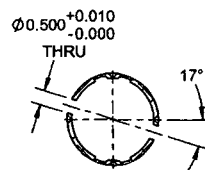
**DETAIL T**  
SCALE 2X



**DETAIL U**  
SCALE 2X



**SECTION W-W**  
SCALE 3X, 4 PL



**SECTION X-X**  
SCALE 3X, 4 PL

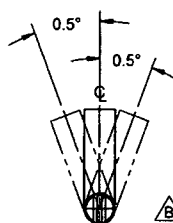
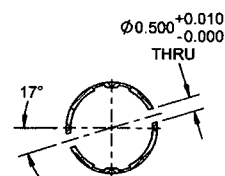
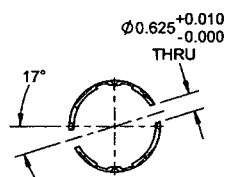
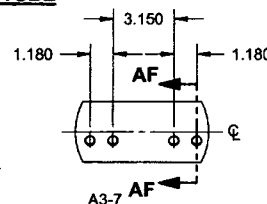
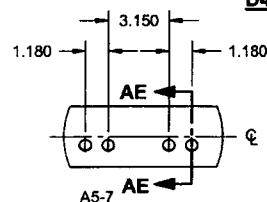
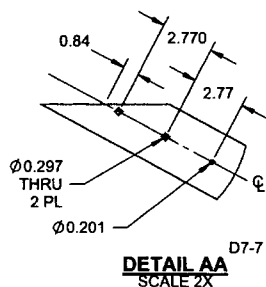
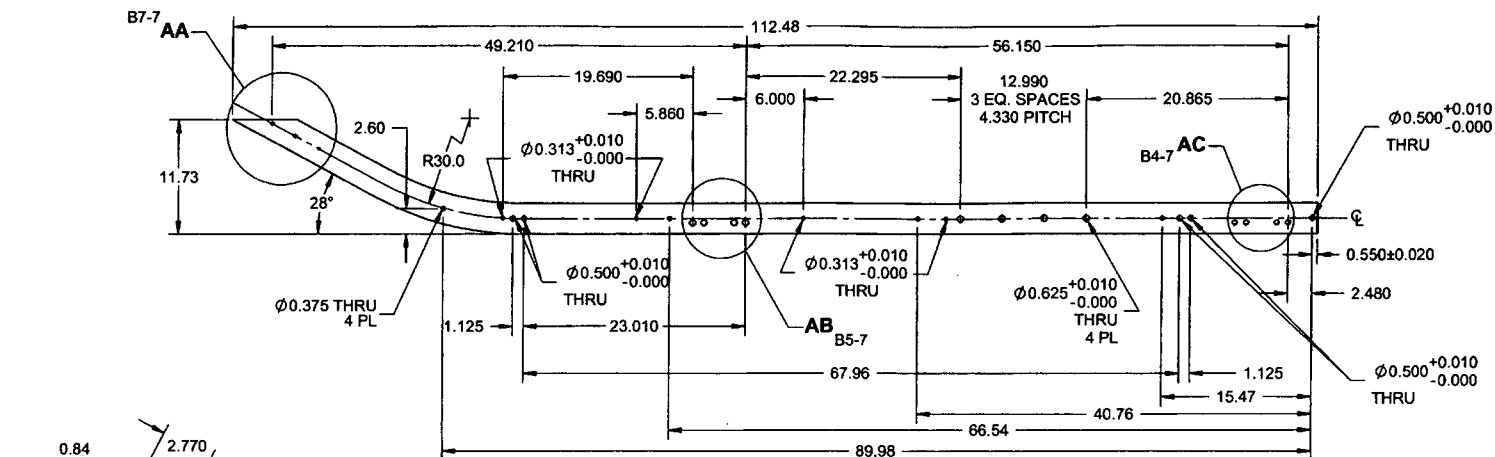
**RELEASED**  
2013-08-13

DESIGN  
DRAWN  
CHECKED  
MFG. APPR.  
APPROVED  
DE APPR.  
DATE 13.07.11

**DART AEROSPACE USA, INC.**  
KENT, WA

DRAWING NO.  
**D4168**  
TITLE  
**350 SKIDTUBE ASSEMBLY**  
REV. B  
SHEET 6 OF 11  
SCALE  
NTS  
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

8 7 6 5 4 3 2 1



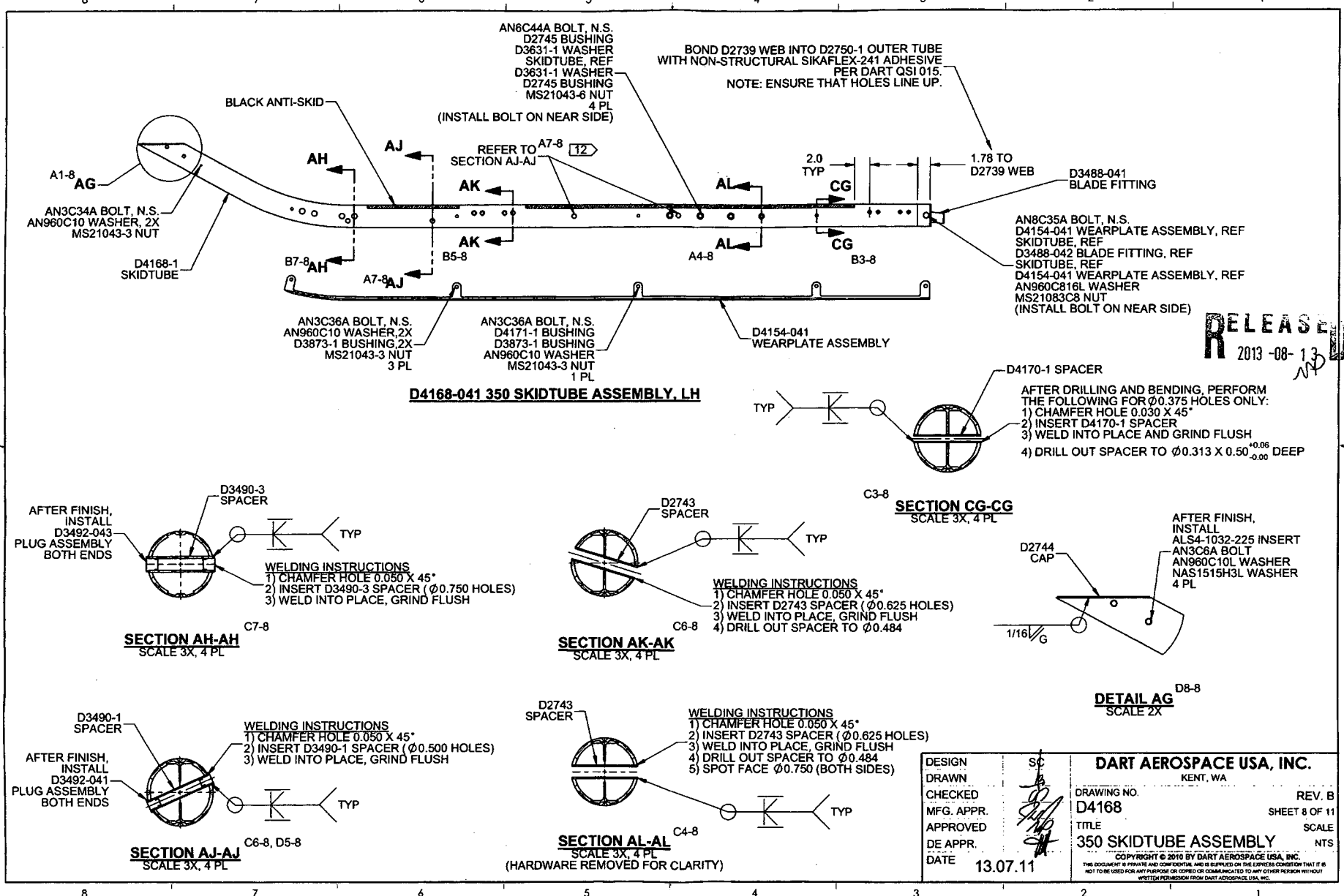
**OUTBD**  
MAX ALLOWABLE  
TWIST ON FWD BEND  
(VIEWED LOOKING FWD)

**RELEASED**  
2013-08-13  
JMP

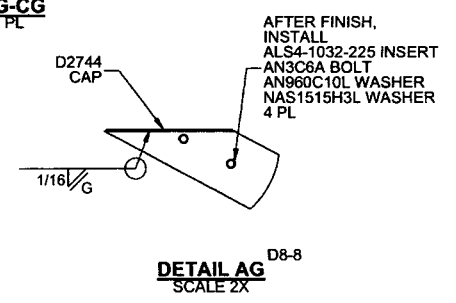
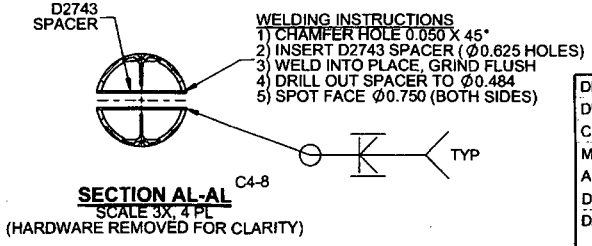
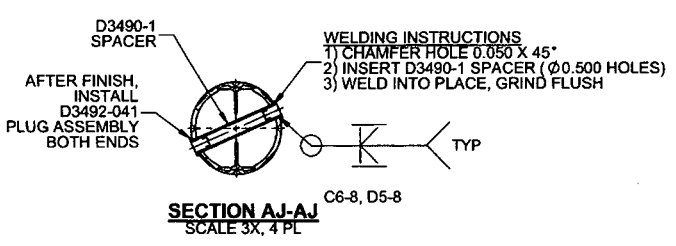
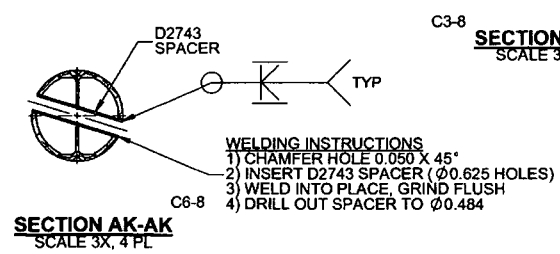
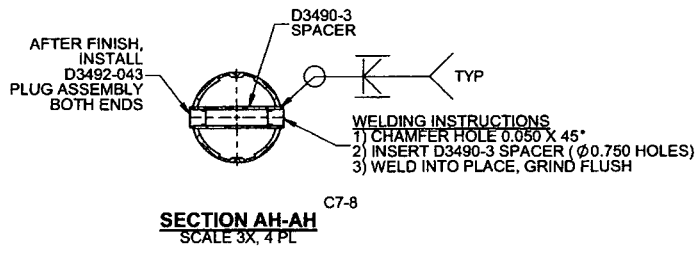
DESIGN	SC	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	JB	KENT, WA	
CHECKED	JB		
MFG. APPR.	JB	DRAWING NO.	REV. B
APPROVED	JB	<b>D4168</b>	SHEET 7 OF 11
DE APPR.	JB	TITLE	SCALE
DATE	13.07.11	<b>350 SKIDTUBE ASSEMBLY</b>	NTS
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.			

8 7 6 5 4 3 2 1





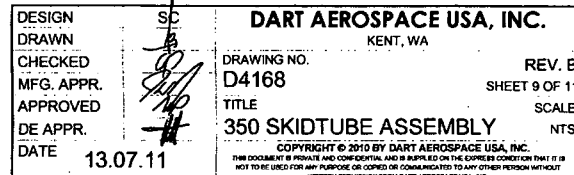
**RELEASE**  
2013-08-13

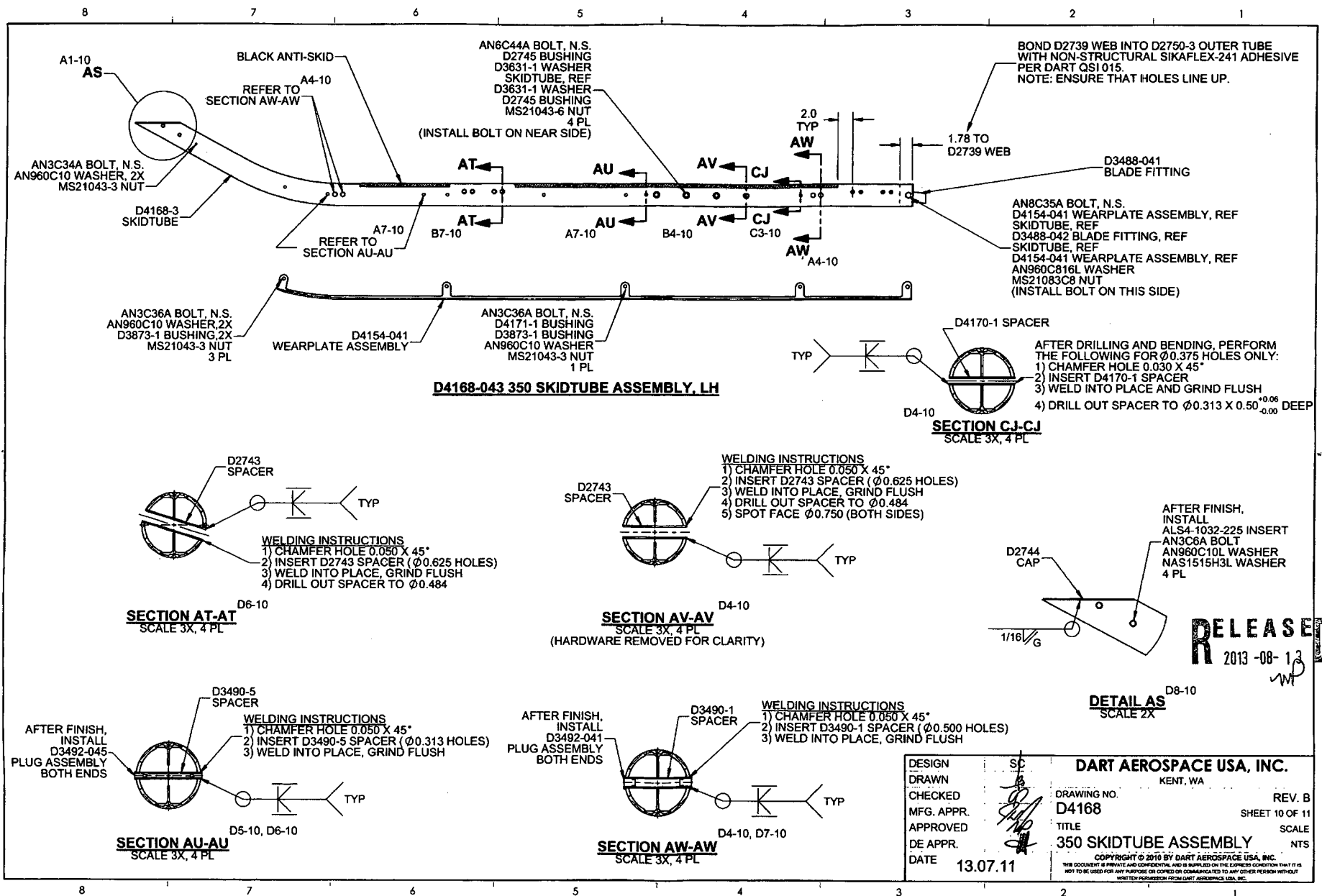


DESIGN DRAWN	  	<b>DART AEROSPACE USA, INC.</b>	
CHECKED		KENT, WA	
MFG. APPR.		DRAWING NO. <b>D4168</b>	REV. B
APPROVED		TITLE <b>350 SKIDTUBE ASSEMBLY</b>	SHEET 8 OF 11
DE APPR.		DATE <b>13.07.11</b>	SCALE NTS

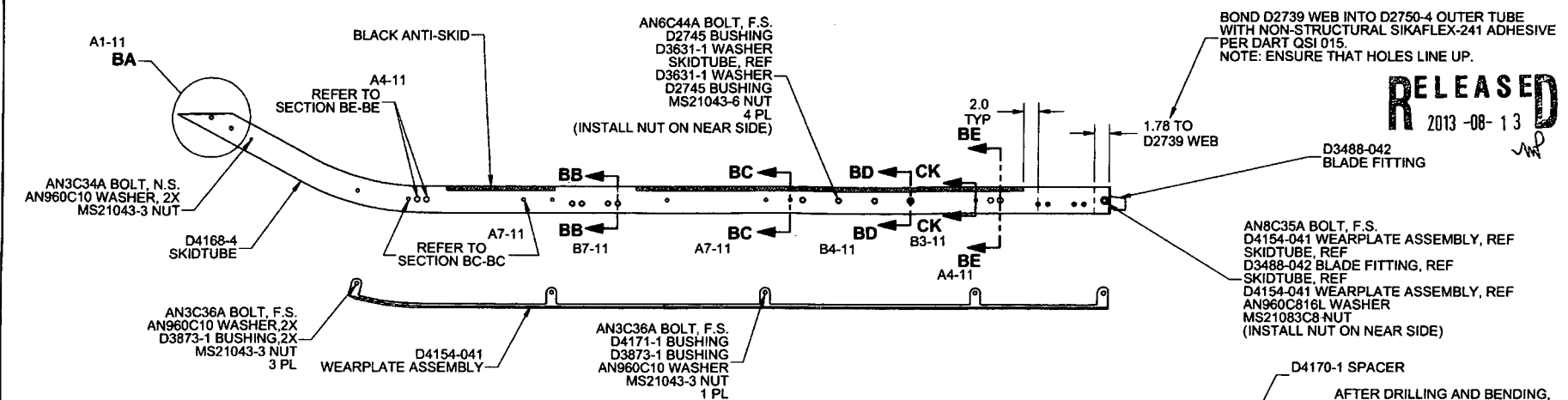
COPYRIGHT © 2010 BY DART AEROSPACE USA, INC.  
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.

2013 -08- 15

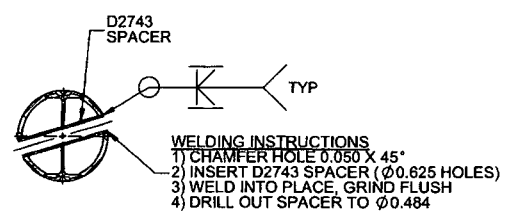




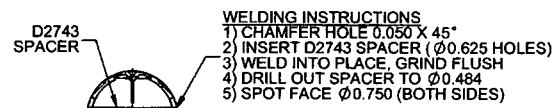
8 7 6 5 4 3 2 1



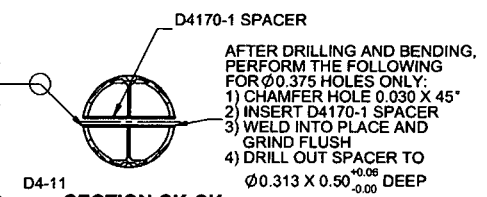
**D4168-044 350 SKIDTUBE ASSEMBLY, RH**



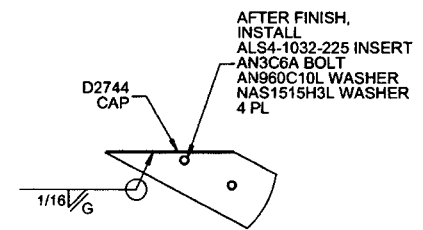
**SECTION BB-BB**  
SCALE 3X, 4 PL



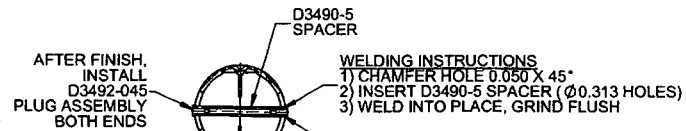
**SECTION BD-BD**  
SCALE 3X, 4 PL  
(HARDWARE REMOVED FOR CLARITY)



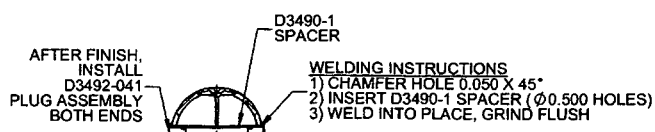
**SECTION CK-CK**  
SCALE 3X, 4 PL



**DETAIL BA**  
SCALE 2X



**SECTION BC-BC**  
SCALE 3X, 4 PL



**SECTION BE-BE**  
SCALE 3X, 4 PL

DESIGN		SC		DART AEROSPACE USA, INC.	
DRAWN		JL		KENT, WA	
CHECKED		JL		DRAWING NO. D4168	
MFG. APPR.		JL		REV. B	
APPROVED		JL		SHEET 11 OF 11	
DE APPR.		JL		SCALE NTS	
DATE 13.07.11				TITLE 350 SKIDTUBE ASSEMBLY	
<small>COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMERCIALIZED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>					

**Linda Lacelle**

**From:** Patrick Smith  
**Sent:** May-29-14 1:29 PM  
**To:** Linda Lacelle; Mike Petsche  
**Cc:** Nigel Forbes; Eric Downing; Nancy MacLeod; David Shepherd  
**Subject:** RE: 350 skids and 206 skids

*PAR 14-338*

Linda,

I spoke with David and he would allow us to use a RTV product to bond the Plugs into the Skidtube.

The existing Plugs would require:

- 1) Removal from the Skidtube
- 2) Removal of the current O-Ring
- 3) Cleaning with Alcohol
- 4) Installation of NEW O-Ring
- 5) Generous coating of the RTV
- 6) Insertion of plug into the Spacer
- 7) Clean up of exterior of Skidtube.

Pat

---

**From:** Linda Lacelle  
**Sent:** May-29-14 10:21 AM  
**To:** Mike Petsche  
**Cc:** Nigel Forbes; Patrick Smith; Eric Downing; Nancy MacLeod  
**Subject:** 350 skids and 206 skids  
**Importance:** High

I heard yesterday that plugs were falling out. Today we were told that we cannot ship any 350 skids. We have an order to ship today, has there been a solution found to fix this problem? Can we not just sikaflex them in or something? We need to let the customer know if his order is shipping or not...

Thx

Linda

*[Handwritten signature]*

## Linda Lacelle

---

**From:** David Shepherd  
**Sent:** June-24-14 1:00 AM  
**To:** Chris Provencal  
**Cc:** Mike Petsche; Linda Lacelle  
**Subject:** RE: plugs on skidtubes

Chris,

Sorry for the delay in getting back to you on this.

If these are the only plugs that we are having a problem with, then I am OK with leaving them out of the skidtubes since the holes that are being plugged are so small. Seems weird to me that we've suddenly started to have a problem, but whatever.

Can I assume from your email that the rest of the plugs are OK?

Regards,  
David

---

**From:** Chris Provencal  
**Sent:** June-04-14 10:59 AM  
**To:** David Shepherd  
**Cc:** Mike Petsche  
**Subject:** RE: plugs on skidtubes

David,

When installing D3492-045 plugs into the 3/16" holes for D4168-043 Skidtubes (AS 350), the o-rings are ripping. See the attached photos for one of the plugs. The effected hole is section AU-AU from the attached pdf page. This is causing some of the plugs to fall out when handling them.

I tried a new plug (D3492-5) and new o-ring (NAS1611-005) with an unpainted D3890-5 spacer (0.197 ID) and could not get it installed without the same ripping. We enlarged a spacer to 0.206" ID and put a 0.220"x45deg c'sink (about the OD of the o-ring) hoping it would force the o-ring into the hole. It ripped less, but the o-ring just doesn't want to compress that much. Some of the o-ring always wants to squeeze out and it gets sheared off when you try to force the plug in (it takes a lot of force to get it in).

I don't know how we've been doing this in the past. We only noticed the problem this time during final packaging of the latest batch.